

Date: Tuesday, 23/12/2008 1:22:57 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	N1 GEARBOX ACCESS PANEL KIT
Job Number :	44300		
Estimate Number :	12504		
P.O. Number :		Part Number :	D3255042
This Issue :	23/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3255 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	42761	Drawing Revision :	B
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	20/01/2009
Written By :		Qty:	1x/2 Um: Each
Checked & Approved By :			
Comment :	Est Rev: 0 Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description
1.0	D32552	Panel
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Panel Batch: <u>B40940</u> → 2x		
2.0	D32553	Cap
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Cap Batch: <u>B44333</u> → 2x		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Weld as per Dwg D3255 ***purge weld*** A/R SS ROD Batch: <u>M101213</u> 2-Grind Welds Flush		
4.0	QC10	VISUAL INSPECTION OF GROUND WELDS
Comment: VISUAL INSPECTION OF GROUND WELDS		
5.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3255-042 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: A Date: 09/04/28
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44300</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09-04-28</u>	<u>2</u>	<u>Material too thin (by grinding) and could not be reworked 28</u>	<u>[Signature]</u> <u>09-04-28</u>	<u>Scrap & destroy</u> <u>28</u>	<u>[Signature]</u> <u>09/04/28</u>	<u>PD</u> <u>09-04-28</u>	<u>[Signature]</u> <u>09-04-28</u>	<u>[Signature]</u> <u>09-04-28</u>

NOTE: Date & initial all entries

Date: → Tuesday, 23/12/2008 1:22:58 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 44300

Part Number: D3255042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0	D32555	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gasket

Batch: _____

9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg D3255

A/R 736 DOW CORNING ADHESIVE Batch: _____

10.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

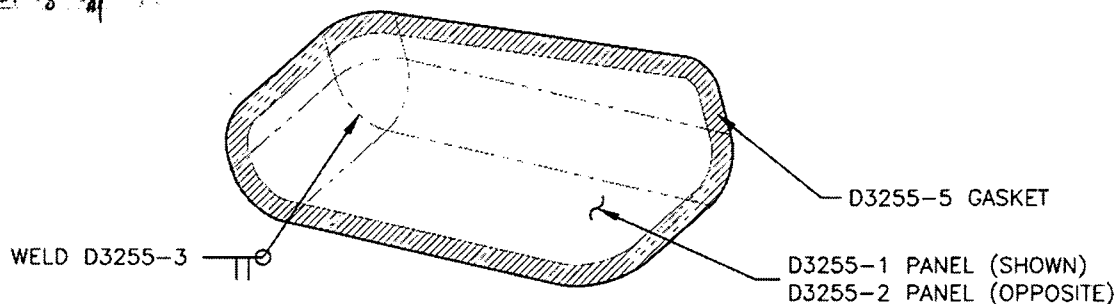
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

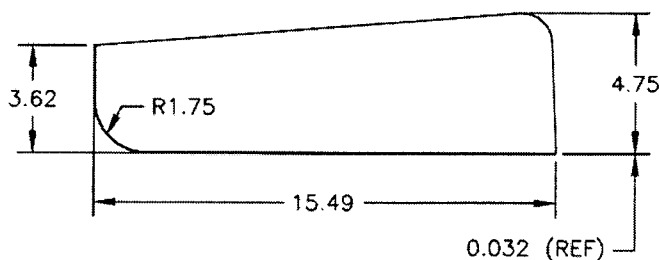
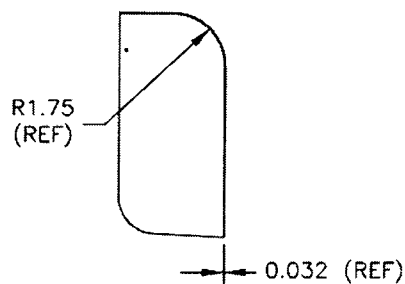
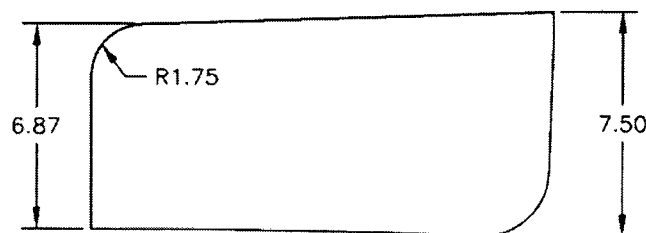


DESIGN PA	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED if	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



w/o
44300

D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

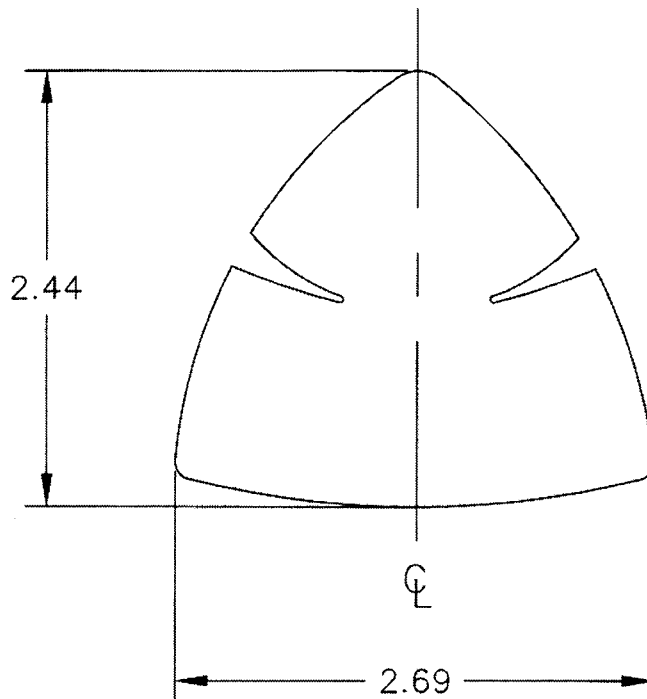
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN TJ	DRAWN BY TJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05-01-08 #



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

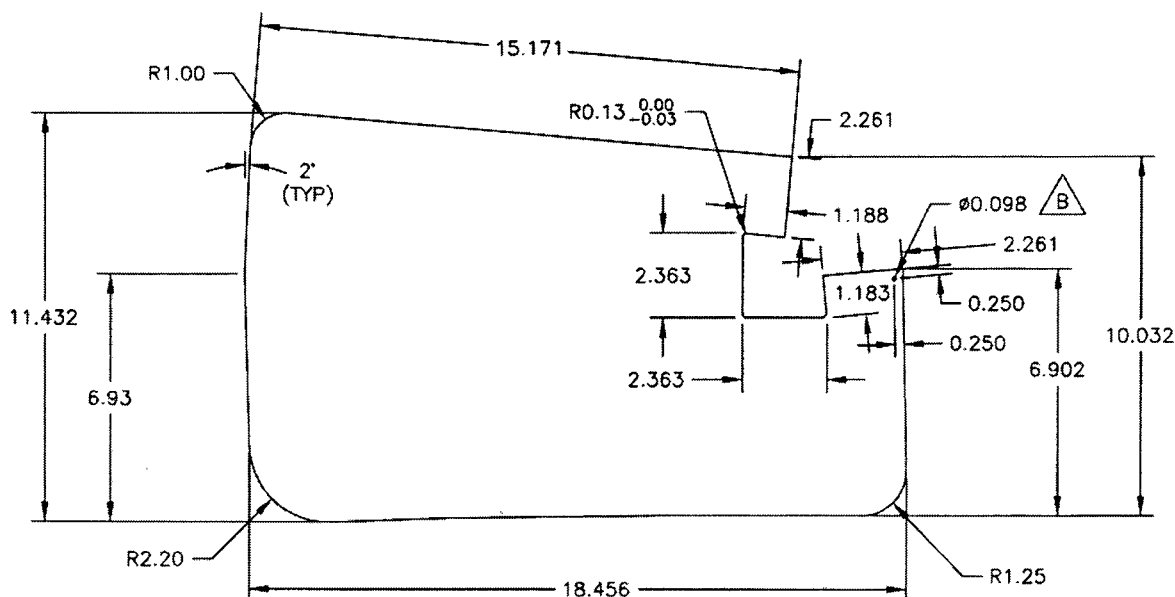
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

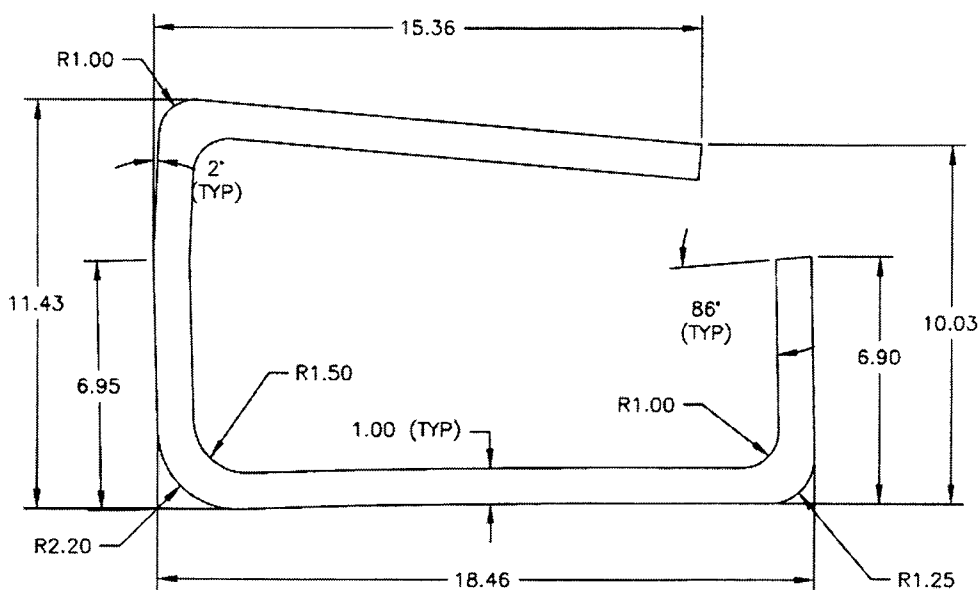
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN 17	DRAWN BY 17	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05 01 18 #**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries